

# Work Order ID 73102

Tuesday, September 20, 2011 1:34:11 PM



~~DUPLICATE~~

Page 1

Item ID: D3197-041

Accept



Setup Start



Revision ID:

Item Name: Bar Assembly

Stop



Start Date: 8/25/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *11-09-20*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3197

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 29.125" long

*mf 11/09/20*

*6*

*0*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Face ends to length per dwg D3197-2-Machine D3197-1 as per Folio FA340  
and Dwg D3197-3-Deburr

*mf 11/09/20*

*6*

*0*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*mf 11/09/20*

*6*

*0*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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Page 2

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Lathe Conv

CONVENTIONAL LATHE

0.00

Conventional Lathe

Memo

Chamfer as per Dwg D3197

0.00

*ml 11/09/21*

*6 0*

140



QC

QC8- Inspect parts - second check

0.00

Quality Control

Memo

0.00

*B.A 11/09/26*

*6 0*

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Hand Finishing

Memo

0.00

*6 0 ml 11/09/22*  
*counted*



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**Work Order ID 73102**

Tuesday, September 20, 2011 1:34:11 PM



Page 4

Item ID: D3197-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar Assembly

Start Date: 8/25/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

0.00 *5 m 09/27*

QC

Memo

Quality Control



200

Identify as per dwg & Stock Location: *260*

0.00



0.00

Packaging

Memo

Packaging

*11/9/27*

210

QC21- Final Inspection - Work Order Release

0.00



0.00

QC

Memo

Quality Control

*11/9/27* *MF 11-09-27*



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**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, September 20, 2011 1:34:08 PM

Page 1

Work Order ID: 73102

Parent Item: D3197-041

Parent Item Name: Bar Assembly





Start Date: 8/25/2011

Required Date: 10/7/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A New Issue 05-11-08 JLM  
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-24  Screw		Purchased	No			100	Each	98.0000	2	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST292		98							
					100151	98							
AN960JD10  Washer	NAS1149D0363J	Purchased	No			180	Each	0.0000	6	36			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
						98							
						98							
D2690-5  Lanyard Assembly		Manufactured	No			180	Each	21.0000	2	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST020		21							
					70390	9							
					73321	12							
D3242-1  Tag		Manufactured	No			180	Each	24.0000	2	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		4							
					70154	4							
				ST044		20							
					71176	8							
					73502	12							

4D M117601 (36x)

Handwritten notes and signatures: 5/11/09/27, 12, 36, 12, 12, 4, 8



W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, September 20, 2011 1:34:08 PM

Page 2

Work Order ID: 73102

Parent Item: D3197-041

Parent Item Name: Bar Assembly

Start Date: 8/25/2011

Required Date: 10/7/2011

Start Qty: 6.00

Required Qty: 6.00

D3489-3-200

Manufactured No

180 Each

24.0000

2

12



PIP PIN



*ES 11/09/27*

Location

Loc Qty

Loc Code

GA

21

71172

9

73503

12

ST062

3

70271

3

*9  
3*

M7075T73R1.000

Purchased

No

180

f

34.0900

2.42

18.15



7075-T73 Rd Bar 1.00

Location

Loc Qty

Loc Code

MAT012

34.09

115165

2.7

116405

4.54

116604

2.25

116835

2.32

116962

0.905

118304

9.375

118305

12

*18.15 and 11/09/20*

MS21042L3

Purchased

No

180

Each

2,592.000

2

12



Nut

*ES 11/09/27*

Location

Loc Qty

Loc Code

ST300

2592

117441

24

117601

363

117885

205

118451

1000

118927

1000

*12*

Tuesday, September 20, 2011 1:34:08 PM

Shop Packet Print

Page 2



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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 73102
<b>Description:</b> Bar		<b>Part Number:</b> D3197-1
<b>Inspection Dwg:</b> D3197	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.000	/		M-type	11-04
25.06	+/-0.030	25.060	/		"	
11.44	+/-0.030	11.440	/		"	
0.500	+/-0.010	.500	/		Vern	21-06
0.250	+/-0.030	.260	/		"	
Ø0.219	+0.005/-0.000	Ø.220	/		"	
Ø0.191	+0.005/-0.000	Ø.192	/		"	
1.000	+/-0.005	1.000	/		"	
2.69	+/-0.030	2.680	/		"	
1.000	+/-0.010	1.000	/		"	
0.300	+/-0.010	.300	/		"	
0.063 x 45°	+/-0.010	.060	/		"	
Ø1.000	+/-0.010	Ø.997	/		"	

<b>Measured by:</b> <i>mf</i>	<b>Audited by:</b> <i>ba</i>	<b>Prototype Approval:</b> N/A
<b>Date:</b> 11/09/26	<b>Date:</b> 11/09/26	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3197-041)	KJ/JLM	
B	07.03.09	Dwg revision update	KJ/JLM <i>JA</i>	<i>BE</i>



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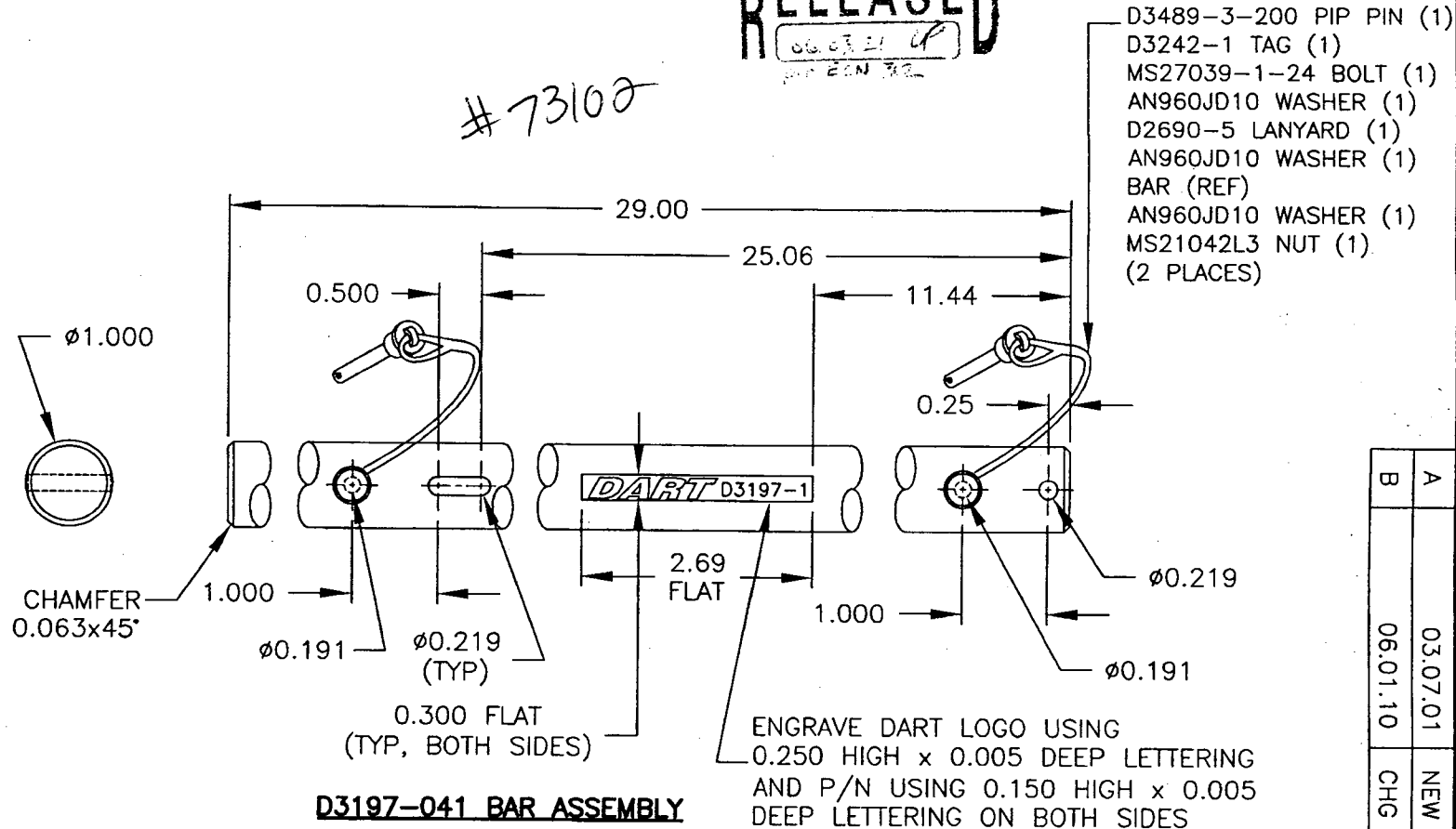
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RELEASED

#73102



- D3489-3-200 PIP PIN (1)
- D3242-1 TAG (1)
- MS27039-1-24 BOLT (1)
- AN960JD10 WASHER (1)
- D2690-5 LANYARD (1)
- AN960JD10 WASHER (1)
- BAR (REF)
- AN960JD10 WASHER (1)
- MS21042L3 NUT (1)
- (2 PLACES)

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.10	DATE	03.07.01	DRAWING NO. D3197 /
		TITLE	BAR	REV. B
				SHEET 1 OF 1
				SCALE 1:1
				CHG PIP PIN: ADD D3242-1 TAG

### D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9)  $\phi$ 1.000 O.D.  
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER  
END OF THE BAR



W/O:		WORK ORDER CHANGES					
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